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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBEA62309
Job Sheet 179173



Part No: RBEA62309

Job Qty: 1 ea

Part Name: AS350/355 Field Maintenance



Part Weight: 0 lbs

Status: At Planning

Priority: Medium

Job Created: 6/14/18

Job Tracking No:

Due Date: 8/15/18

Created By: Logan David

Type: Stock

Description:

Note: RBEA62309 rev.12 IPP REV:A 17.12.13 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Start up Operation	1 Ea	8/15/18	8/15/18	0.00	0.00	Start Up Small Fab-4		MLC
105	Smail Fab	1 pcs	8/15/18	8/15/18	0.00	1.00	Small Fab-9		MLC DAS 38
120	QC	1 pcs	8/15/18	8/15/18	0.00	0.00	QC5		38
130	Packaging	1 pcs	8/15/18	8/15/18	0.00	0.00	Packaging3-2		DEC 07 2018
140	QC21-FG	1 Ea	8/15/18	8/15/18	0.00	0.00	QC21		DEC 07 2018

Part Op 105 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
Descriptions: APP-1700-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Install placard to wheel housing as per DWG 6-Glue foam to case and pack case 7- See note 1 for hoses

DAS
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9-89



Container No: S111066



Part: RBEA62309

Job No: 179173

Serial No/Batch: S111066

Revision: 12

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
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www.dartaerospace.com

Date: 09/18/18

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	100-Start up Operation	5021040
3896T31	Ferule 1/16 X 3/8" - Aluminum	2 Ea (2 ea)	105-Small Fab	5038398
5274T761	Polypropylene Vial for Flange Wrench Bolts	1 Ea (1 ea)	105-Small Fab	5098891
7189K31	Cable Ties Black	9 Ea (9 ea)	105-Small Fab	5038430
86625K31	Grommet Size 00	1 Ea (1 ea)	105-Small Fab	5038427
9052000	10" Mini Bungee Cord	4 Ea (4 ea)	105-Small Fab	5094611 5094609 X2
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	105-Small Fab	5094611 X2
97526A421	Rivet	4 Ea (4 ea)	105-Small Fab	5038428
APP-1700-E	Hard Case	1 Ea (1 ea)	105-Small Fab	5092387
CL-194-TERM-2	Eyelet	1 Ea (1 ea)	105-Small Fab	5041609
CL-2-C	Lanyard Wire	1.1600 ft (1.16 ea)	105-Small Fab	5093863
NAS1756-12	Remove Before Flight	1 Ea (1 ea)	105-Small Fab	5094792
RBE-350DAMPER	Damper Spanner Wrench	1 Ea (1 ea)	105-Small Fab	5107758
RBE-350HYD	Hydraulic Accumulator Fitting Gauge	1 Ea (1 ea)	105-Small Fab	5115954
RBE-350INCLINOMETER	Inclinometer	1 Ea (1 ea)	105-Small Fab	5064583
RBE-350TDRS	Tail Rotor Driveshaft Bearing Run-Out Gauge	1 Ea (1 ea)	105-Small Fab	5115851
RBE-350TEMP	Temperature Probe	1 Ea (1 ea)	105-Small Fab	5098179
RBE350A93-3200-20-1	Main Gear Box/Rotor Brake Retaining Nut Wrench	1 Ea (1 ea)	105-Small Fab	5094419
RBE350A93-3205-00E	Engine G/B Input Flange Holding Wrench	1 Ea (1 ea)	105-Small Fab	5096004
RBE350A93-3205-00T	Tail Rotor Gear Box Input Flange Holding Wrench	1 Ea (1 ea)	105-Small Fab	5096015
RBE350A93-3300-20	Tail Rotor Hub Socket	1 Ea (1 ea)	105-Small Fab	5117389
RBE350A93-3302-02	Tail Rotor Hub Lock Wrench	1 Ea (1 ea)	105-Small Fab	5123228
RBE350A93-3303-02	Tail Rotor Head Body Extractor Tool	1 Ea (1 ea)	105-Small Fab	5129754
RBE350A93-3305-20-1	Tail Gearbox Wrench	1 Ea (1 ea)	105-Small Fab	5129027
RBE350A93-3307-00	Tail Gearbox Seal Extractor	1 Ea (1 ea)	105-Small Fab	5121659
RBE350A93-3312-03	Tail Rotor Hub Bushing Replacement Tool	1 Ea (1 ea)	105-Small Fab	5121708
RBE350A93-3316-20	Rotating Star Replacement Wrench	1 Ea (1 ea)	105-Small Fab	5107555
RBE350A93-3317-20	Tail Rotor Hub Insert Tool	1 Ea (1 ea)	105-Small Fab	5115575
RBE350A93-3400-00	Drive Shaft Thimble	1 Ea (1 ea)	105-Small Fab	5115898
RBE350A93-3500-00	Bearing Extractor	1 Ea (1 ea)	105-Small Fab	5113151
RBE350A93-3501-20	Extraction Tool, Hydraulic Pump Pulley Bearing	1 Ea (1 ea)	105-Small Fab	5045019
RBE350A94-2704-00	Pedals Locking Tool	1 Ea (1 ea)	105-Small Fab	6121872
RBE350A94-2706-00	Rigging Pin Set	1 Ea (1 ea)	105-Small Fab	5116133
RBE350A94-2708-01	Tail Rotor Blade Locking Tool	1 Ea (1 ea)	105-Small Fab	5113304
RBE350A94-3301-00	T/R Accelerator Support	1 Ea (1 ea)	105-Small Fab	5113375
RBE350A94-3700-A	Swashplate Immobilizing Tools Long Brace & Parts	1 Ea (1 ea)	105-Small Fab	5115529
RBE350A94-3700-C	Swashplate Immobilizing Tool Adjustable Brace	1 Ea (1 ea)	105-Small Fab	5131658
RBE350A94-3701-00	Main Rotor Rigging Tool	1 Ea (1 ea)	105-Small Fab	5101757
RBE350A94-5201-20	Cartridge, Dummy, Fuel	1 Ea (1 ea)	105-Small Fab	5117215
RBE703A94-1130-01	Main Rotor Blade Trim Tab Tools Assembly	1 Ea (1 ea)	105-Small Fab	5135290
RBE703A95-0505-00	Hose, Main Gear Box Tail Gear Box Draining	1 Ea (1 ea)	105-Small Fab	5116692
RBE703A95-0508-00	Main Rotor Gear Box Drain Tube	1 Ea (1 ea)	105-Small Fab	5028556
RBE703A95-0520-01	Engine And Hydraulic Drain Tube	1 Ea (1 ea)	105-Small Fab	5132633
RBE703A95-0520-01-11	Tube	1 (1 ea)	105-Small Fab	/ / /
RBE703A95-0520-01-13	Cap	1 (1 ea)	105-Small Fab	/ / /
RBE703A95-0520-01-15	Foam	1 (1 ea)	105-Small Fab	/ / /
RBEA62309-65	Laminated Location Card	1 Ea (1 ea)	105-Small Fab	5088321 5053656
RBEA62309-81	Top Shelf Cushion	1 Ea (1 ea)	105-Small Fab	5092350
RBEA62309-82	Top Cushion Stiffener	1 Ea (1 ea)	105-Small Fab	5092365
RBEA62309-83	Bottom Shelf Cushion	1 Ea (1 ea)	105-Small Fab	5092380
RBEA62310	AS350/355 Engine Strut	1 Ea (1 ea)	105-Small Fab	5131300
RBT18025-13	Linear Scale (50 lbs)	1 Ea (1 ea)	105-Small Fab	5095819
RBW109-3101-58-1-1	Hammer, Steel	1 Ea (1 ea)	105-Small Fab	5135372
RBW109-3101-58-2-1	Hammer, Aluminum	1 Ea (1 ea)	105-Small Fab	5135402

Job Allocations

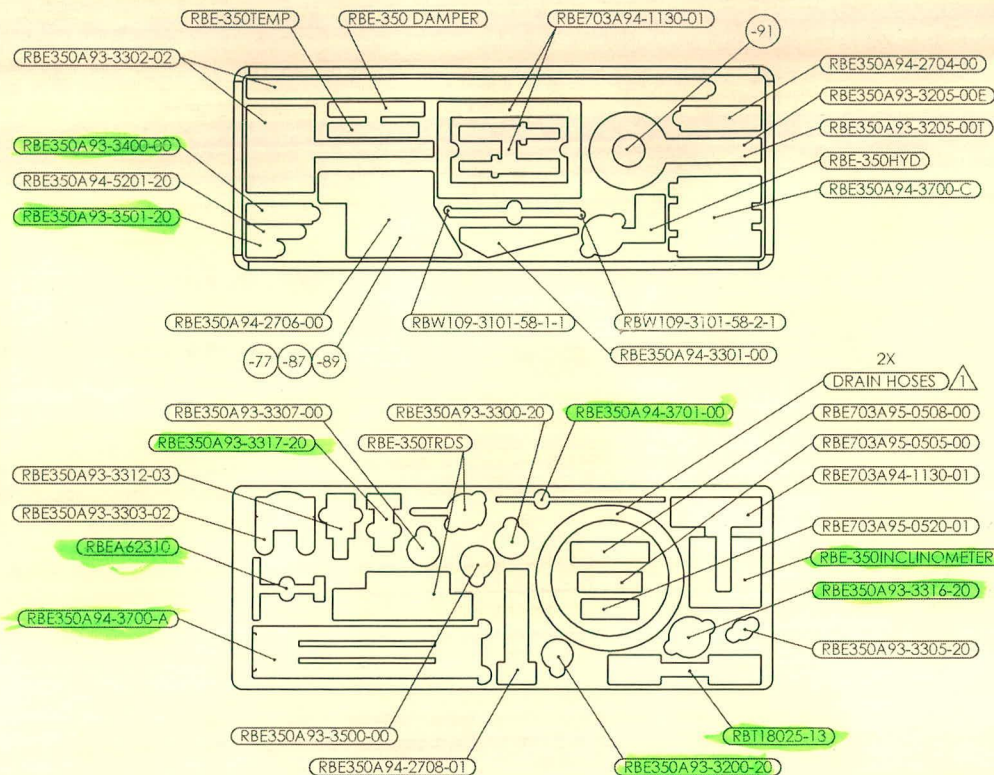
Operation	Component Part	Required	Inventory	Allocated
100-Start up Operation	RB41011	1	887	0
	3896T31	2	498	0
105-Small Fab	5274T761	1	10	0
	7189K31	9	1,000	0
	86625K31	1	50	0
	9052000	4	36	0
	97524A032	4	383	0
	97526A421	4	100	0
	APP-1700-E	1	17	0
	CL-.194-TERM-2	1	50	0
	CL-2-C	1	319	0
	NAS1756-12	1	377	0
	RBE-350DAMPER	1	1	0
	RBE-350HYD	1	10	0
	RBE-350INCLINOMETER	1	14	0
	RBE-350TDRS	1	9	0
	RBE-350TEMP	1	1	0
	RBE350A93-3200-20	1	1	0
	RBE350A93-3205-00E	1	8	0
	RBE350A93-3205-00T	1	9	0
	RBE350A93-3300-20	1	12	0
	RBE350A93-3302-02	1	0	0
	RBE350A93-3303-02	1	1	0
	RBE350A93-3305-20	1	0	0
	RBE350A93-3307-00	1	1	0
	RBE350A93-3312-03	1	0	0
	RBE350A93-3316-20	1	1	0
	RBE350A93-3317-20	1	1	0
	RBE350A93-3400-00	1	1	0
	RBE350A93-3500-00	1	0	0
	RBE350A93-3501-20	1	14	0
	RBE350A94-2704-00	1	10	0
	RBE350A94-2706-00	1	1	0
	RBE350A94-2708-01	1	1	0
	RBE350A94-3301-00	1	13	0
	RBE350A94-3700-A	1	2	0
	RBE350A94-3700-C	1	0	0
	RBE350A94-3701-00	1	29	0
	RBE350A94-5201-20	1	11	0
	RBE703A94-1130-01	1	1	0
	RBE703A95-0505-00	1	1	0
	RBE703A95-0508-00	1	3	0
	RBE703A95-0520-01	1	0	0
	RBE703A95-0520-01-11	1	0	0
	RBE703A95-0520-01-13	1	0	0
	RBE703A95-0520-01-15	1	0	0
	RBEA62309-65	1	35	0
	RBEA62309-81	1	8	0
	RBEA62309-82	1	13	0
	RBEA62309-83	1	8	0
	RBEA62310	1	1	0
	RBT18025-13	1	17	0
	RBW109-3101-58-1-1	1	6	0
	RBW109-3101-58-2-1	1	0	0

Part Specifications

Specifications could not be found.

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-81 REARRANGED TOP SHELF TOOLS. -83 RECONFIGURED BOTTOM SHELF TOOL ARRANGEMENT TO BETTER FIT RED BARN TOOLS. -65 RECONFIGURED TOP AND BOTTOM SHELF TOOL ARRANGEMENT TO BETTER FIT RED BARN TOOLS. ADDED LAMINATED LOCATOR CARD AND LANTARD COMPONENTS.	9/22/2009	WP	
2		REDRAWN TO USE HELI-PRODUCTS TOOLS AND ALLOW FOR 3 DRAIN HOSES	1/25/2010	WP	RW
2A		ADDED NEW RED BARN PHOTOS.	2/11/2010	RJC	PW
3		-81 REARRANGED TOP SHELF TOOLS. -83 REARRANGED BOTTOM SHELF TOOL CUSHION TO ACCOMMODATE NEW DIGITAL TORPEDO LEVEL. ADDED SECTION A-A TO CLARIFY CUT OUT FOR RBEA62310-03. CHD CUTOUT DEPTH FOR RBEA62310-03. RBEA62310-03 & RBEA93-3501-20. -65 REARRANGED TOP AND BOTTOM SHELF CUSHIONS TO ACCOMMODATE NEW DIGITAL TORPEDO LEVEL. CHD CARD INFORMATION FOR LA 5.	2/18/2010	RJC	
4		-83 REARRANGED TOOL CUTOUPS. ADDED CUT OUT FOR RBEA62310. -65 UPDATED CARD.	3/9/2010	WP	
4A		-87 & -51 CHD QTY. FROM 3 TO 1 SET. UPDATED LAYOUT PHOTOS.	5/26/2010	PJC	
4B		-87 & -89 ADDED ONE TO EACH QTY.	7/21/2010	WP	RW
4C		-91 ADDED CONTAINER FOR RBEA93-3205-00-1 & RBEA93-3205-00-03 NUTS & BOLTS.	10/27/2010	WP	DW
5		-81 DELETED CUTOUT NOTCHES FOR RBE-RDGS-15.	6/20/2011	RJC	PW
6		CORRECTED DRAIN HOSE 1/IN FROM RBEA93-0502-01 TO RBEA93-0520-01. -83 CHD FOAM CUTOUPS FOR RBEA93-3300-00. RBEA93-3300-20. RBEA93-3200-20 & RBEA93-3317-20 FOR BETTER FIT. -65 UPDATED CARD.	2/27/2012	RJC	DW
7		-83 CHD TOOL LAYOUT. ADDED NEW DESIGN FOR DRAIN HOSES & CUTOUPS FOR INDIVIDUAL OUILLS. CHD CUTOUP FOR RBEA94-3700-A FOR TIGHTER FIT. -65 UPDATED CARD.	1/9/2013	RJC	SE
7A		-45 CORRECTED ITEM QTY FROM RBEA93-3305-02 TO RBEA93-3305-20. CHD QTY. FROM 8 TO 1. ADDED DRAIN HOSE QTY. 2. CHD LOCATION D1 & D2 TO D, AND X1, X2, & X3 TO X.	4/11/2013	RJC	RJC
8		-81 CHD DIM WAS 4.75 B 4.44. -83 CHD CUTOUP LOCATION FOR RBE350A94-3700-A. -65 CORRECTED 1/IN & TOOL DESCRIPTION TO MATCH CURRENT DRAWINGS.	10/24/2013	CFS	DW
9		-81 CHD CUTOUP FOR RBE350HYD (NEW GAUGE). CHD CUTOUP FOR RBE350A94-3700-C TO FIT BETTER. -83 CHD CUTOUP FOR RBE350A94-3700-A TO SECURE TOOL BETTER.	3/25/2014	RJC	DW
10	15-0038	UPDATED TO NEW DRAFTING STANDARDS. -83 CHD FOAM TO ACCOMMODATE SNAP-ON INCLINOMETER. -65 CHD CARD TO SHOW NEW TOOL LAYOUT WITH SNAP-ON INCLINOMETER.	2/11/2015	DPD	JAG
11	16-0149	-81 ADDED DETAIL SHEET. REPLACED RBE-RDGS-15 WITH RBT18025-13 AND MOVED TO -83. ADDED RBW109-3101-58-1 & RBW109-3101-58-2. CHD MATERIAL WAS 120 BLACK E ETHAFOAM 220. BLACK. -82 ADDED DRAWING. -83 ADDED DETAIL SHEET. CHD TOOL LAYOUT. CHD DIM WAS 4X 8.64 IS 3X 6.4 A 45°. DELETED DIMS: 7.5 (2), 18 (2), 1.38 (2) & P.75 (4) SPHERE. AND ADDED DIMS: 7.8, 1.48 & 1.25. CHD FOAM WAS 120 BLACK E ETHAFOAM 220. BLACK. MOVED RBE350A93-3400-00. RBE350A94-3201-20 & RBE350A93-3201-10 -81. -83 RBE-RDGS-15 REPLACED W/ RBT18025-13. -65 REARRANGED TOOLS TOP AND BOTTOM. ADDED RBW109-3101-58-1, RBW109-3101-58-2, RBT18025-13, -77, -87, & -89.	9/20/2016	RJC	JAG
12	17-0013	-81 CHD DIM WAS 8.20 B .82. -83 CHD DETAIL ORGANIZATION: REMOVED DIM 3X 9.88, 3X 1.38, 33.47, 2X 34.17, 2.25, 8.07, 7.13. ADDED DIM 67.75, 30.13, 5.49, 12.77, P.13, R1.38, 5X R.50, 2X R.63, 6X R.13, 8.50. CHD DIM WAS 10.24 B 3X 10.24. WAS 2X 34.88 B 3X 34.88, WAS 12.33 B 8.80, WAS 11.560 B 11.57. -65 REARRANGED TOOLS ON BOTTOM SHELF. UPDATED ITEM 12 & 13 TOOL NUMBERS.	1/24/2017	SM	JAG

NOTE:

7 FT. HOSES MUST COUPLE IN CUTOUP. MIN TRIM ACCEPTABLE.

DART AEROSPACE	
TITLE: AS350-355 FIELD MAINTANANCE KIT	
DWG NO: RBEA62309	REV 12
MAT'L	UNLESS OTHERWISE SPECIFIED
FEAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .010 FRACTIONS & 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES ± 12°
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x .85" OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	3. INTERPRET DIM AND TOL PER
APPROVED: GILBERT	ASME Y13.3M-2009
SCALE 1:8	USED ON MODEL
DATE 9/20/2016	AS350/355
SHEET 1 OF 8	

